

Work Order ID 70456 -1

Wednesday, June 08, 2011 7:37:00 PM

Page 1

Item ID: D2571

Accept

Revision ID:

Item Name: Saddle, Fwd Out 205

Start Date: 6/13/2011 Start Qty: 12.00

Required Date: 6/24/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 70456 Double check by: ☐ 1-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine
Step No 3 per Folio FA051 and inspect

SL 11/06/20 (F)

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

SL 11/06/20

7

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/06/20

7

0

Work Order ID 70456

Wednesday, June 08, 2011 7:37:00 PM



Page 2

Item ID: D2571	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, Fwd Out 205					
Start Date: 6/13/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 6/24/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A		7	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				7	0		11/06/20
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M117964 Memo START TIME: 10:35 FINISH TIME: 11:05	0.00 0.00				7	0		11-6-20.

Work Order ID 70456

Wednesday, June 08, 2011 7:37:00 PM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 6/13/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>433</u>	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

7 0 11 11/06/20

11/6/20 (7) S

11/6/20

MF
11-06-20

Picklist Print

Wednesday, June 08, 2011 7:36:55 PM

Page 1

Work Order ID: 70456



Parent Item: D2571



Parent Item Name: Saddle, Fwd Out 205

Start Date: 6/13/2011

Required Date: 6/24/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-007		Manufactured	No			100	Each	39.0000	1	12			
-----------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--



Saddle Billet



12 11/06/20

Location	Loc Qty	Loc Code
MAT042	9	
66967	9	
MAT045	30	
65383	13	
65954	17	

12

DART AEROSPACE LTD		Work Order: 70456
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		.495	.497	.502	.499		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.499	.500	.497	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.565	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.251	.251	.251		
S	0.115	0.135		.127	.127	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.125	.125	.125	.121		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.365	.365	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.626	.628	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.250	.250	.250		
AE	1.375	1.395		1.387	1.386	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.249	.250	.250	.249		
AI	2.000	2.020		2.002	2.001	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <u> </u>	Audited by: <u> </u>
Date: <u>11/06/15</u>	Date: <u>11/06/20</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 70456
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.438	0.443		.438	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.002	8.002		
F	0.490	0.510		.500	.504	.500	.502		
G	0.257	0.262		.259	.257	.257	.257		
H	0.375	0.380		.377	.376	.376	.376		
I	0.490	0.510		.497	.498	.500	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.563	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.496	1.495	1.495	1.495		
N	2.495	2.505		2.506	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		.127	.128	.128	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.253	.250	.257		
S	0.115	0.135		.132	.132	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.960	2.960	2.960		
V	0.230	0.250		.241	.242	.243	.242		
W	0.115	0.135		.129	.126	.126	.123		
X	0.308	0.313		.310	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.363	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.629	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.251	.249	.252		
AE	1.375	1.395		1.387	1.388	1.388	1.387		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.268	.268	.268	.268		
AH	0.240	0.260		.257	.251	.251	.251		
AI	2.000	2.020		2.002	2.003	2.002	2.002		
AJ	0.023	0.043		.033	.038	.035	.035		
Accept/Reject									







Measured by:	S
Date:	11/16/20

Audited by:	B.A
Date:	11/06/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05-12-06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE PART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

$\triangle E$

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.05	ADD RIDGES, TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEC 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	
DS	PH	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2571
DATE		TITLE
05.07.13		OUTER FWD SADDLE

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DETAIL C
SCALE 4:3

2 shot o/m